

Grades, Speeds & Feeds

Grades

RS20	RS21	RS23	RS27
An uncoated grade K20/K30 micrograin carbide giving outstanding performance on most materials	A TiAlN coated micrograin carbide for universal use giving the highest cutting tool life	A TiN coated micrograin carbide giving outstanding performance on most materials at lower speed	A TiN coated micrograin carbide giving outstanding performance on most materials

Cutting Speeds & Feeds

Materials	Cutting speed m/min			
	RS20	RS21	RS23	RS27
Carbon steel C 0.15% C 0.45% C 0.60%	30 - 110	120 - 200 100 - 200 90 - 180	120 - 200 100 - 200 90 - 180	140 - 220 110 - 200 100 - 180
Alloyed steel Low Medium High	30 - 80	100 - 200 90 - 160 70 - 100	100 - 200 90 - 160 70 - 100	110 - 200 90 - 160 30 - 100
Stainless Steel – Austenitic		30 - 160		50 - 160
Cast Steel Non-alloyed Alloyed		90 - 160 70 - 110	90 - 160	100 - 160 40 - 100
Gray Cast Iron	70 - 90	70 - 160	70 - 160	70 - 160
Aluminium Normal Heat-treatable =50HB Non-heat treatable = 100HB	200 - 250 700 - 850 280 - 350	400 - 1000 200 - 1200 250 - 800	200 - 1200	400 - 1000 250 - 800
Nickel based alloys	20 - 60	30 - 80	30 - 80	30 - 80
Bronze, Brass	90 - 180	90 - 200	90 - 200	90 - 200

Number of cutting passes for thread pitches

Pitch mm	0.5	1.0	1.5	2.0	2.5	3.0	4.0	6.0
TPI	48	24	16	12	10	8	6	4
No of passes	3 - 6	4 - 9	5 - 11	6 - 13	7 - 15	8 - 17	10 - 20	11 - 22